Work Order ID 98011

March-01-13 2:39:37 PM

98011

Item ID: D3272-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Step

Start Date: 3/01/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 3/15/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 13-03-01 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100		0.00							
100	Large Fab								
Large Fab									
Large Fab	**Memo**	0.00							
	SQUARE ONE END BEFORE CUTTING OTHER END								
	1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A								
	2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.								
	3-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									

(10) ø Ae 13.03.06

(15) 13.03.07 DAS 09 8-89

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 98011

March-01-13 2:39:37 PM

98011

Item ID: D3272-1 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Step

Start Date: 3/01/13 **Start Qty:** 10.00 *10*
Required Date: 3/15/13 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: WA003	0.00							
120 Packaging Packaging	**Memo**	0.00				(10)	ϕ	Ale	13-03-07
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC Quality Control	**Memo**	0.00				MCJ			13-03-07

MB 03-7

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
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- ☐ Contamination
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- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-01-13 2:39:41 PM

1

Work Order ID: 98011

98011

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 3/01/13 **Required Date:** 3/15/13

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	781.5300	1	10			
D2622-120C									**				
Step Extrusion													

13·03·04

Location	Loc Qty	Loc Code	
WA003	781.53		
46910	4.83		
64409	6		
66970	7.7		
68293	0.25		
72131	0.42		
75781	9		
77612	19.33		
81507	14.51		
83894	12.38		
88513	7.14		
89750	611.97		
93552	83		(10)
94437	5		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Composite ☐
- Water Jet ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
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Training										
Unapproved										

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- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 — REV. B — SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG — SCALE NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

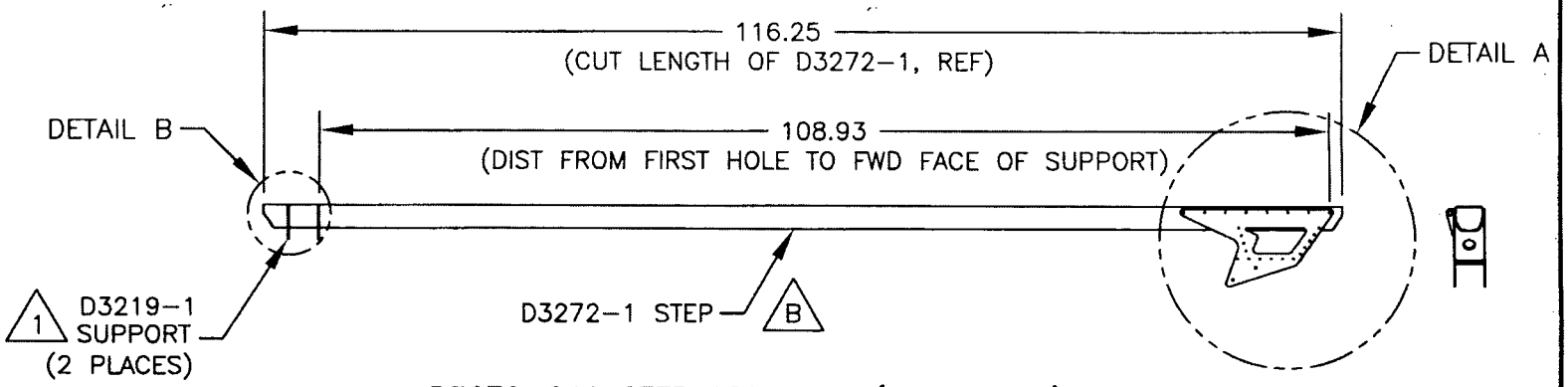
GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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SENT TO
ENGINEERING
CONTROLLED COPY
PART AMENDMENT
PART NOTICE
WORK ORDER
98011
13-03-01

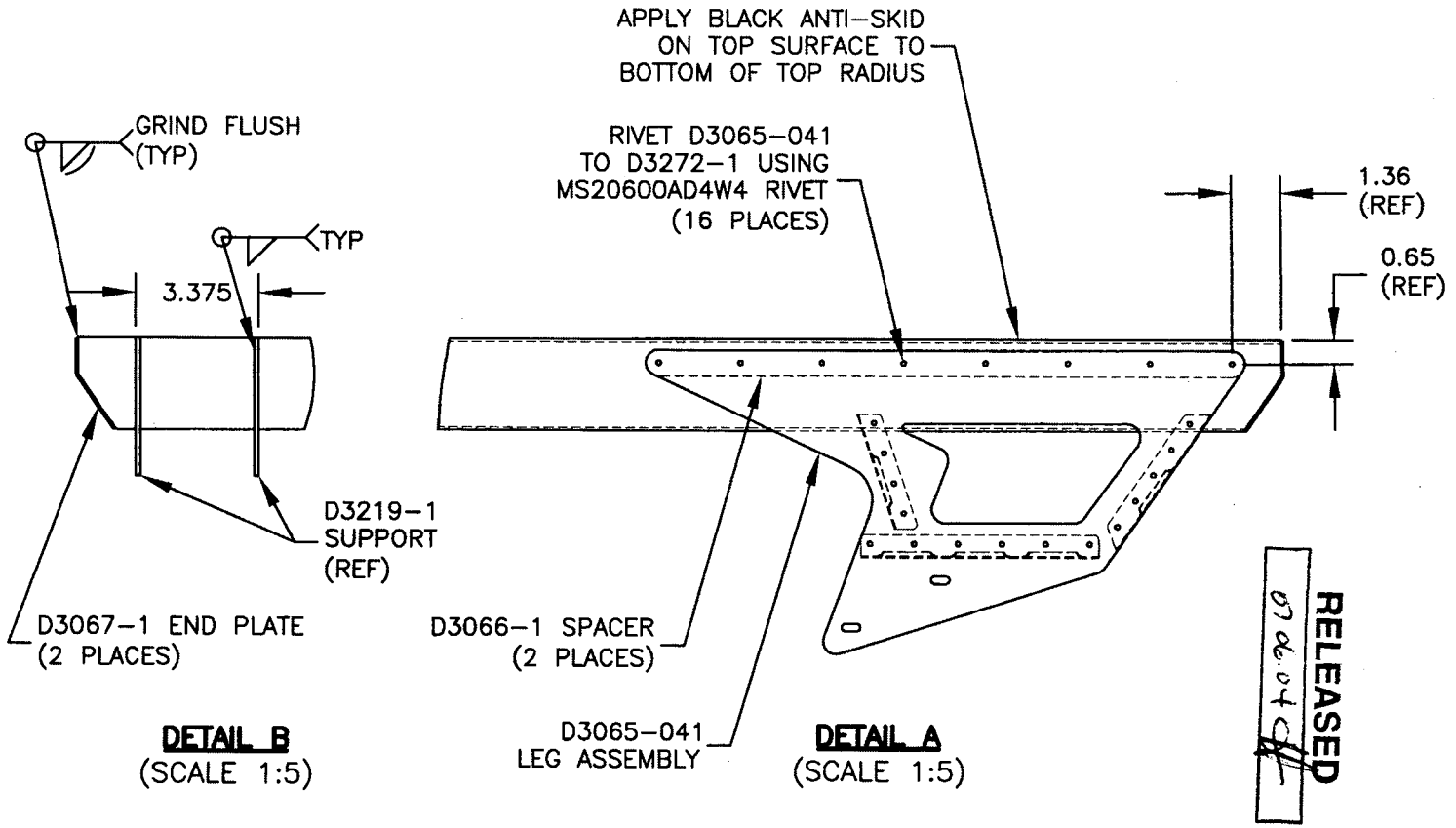
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98011



D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07 de. 04

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

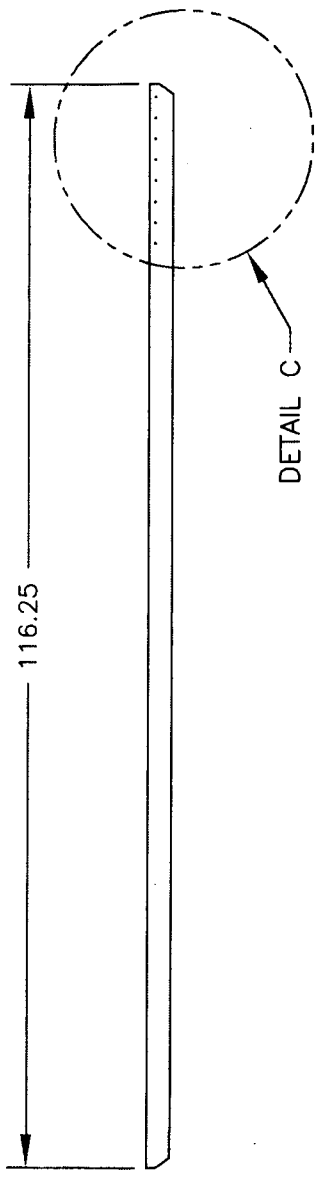
DESIGN	DRAWN BY	DRAWING NO.	REV.
CHECKED	APPROVED	D3272	B
DATE		TITLE	SHEET 2 OF 3
07.05.18		STEP ASSEMBLY, HI LONG	SCALE 1:20

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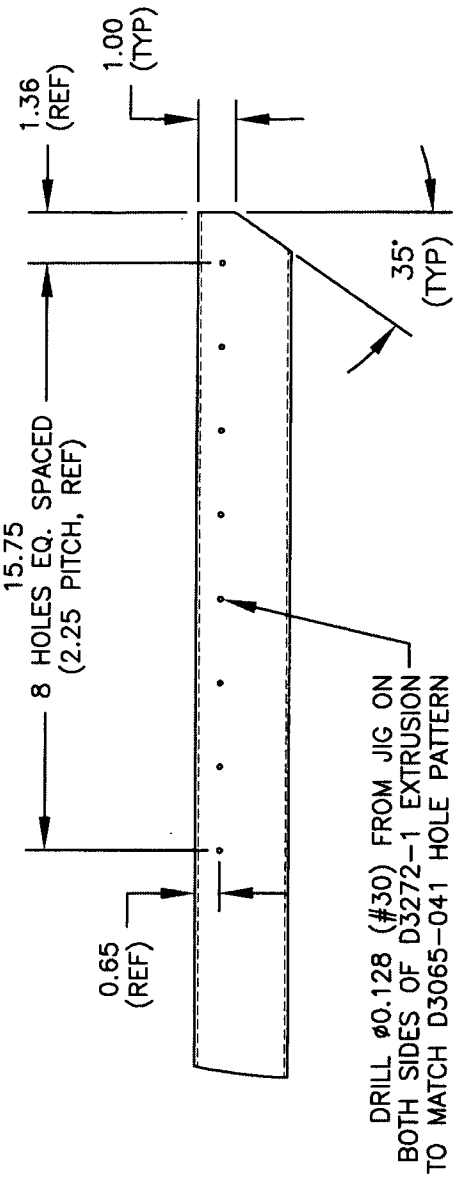
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07 06 04



△B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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